



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D5805-041

Job Sheet 207469



Part No: D5805-041

Job Qty: 1 pcs

Part Name: Attachment Hoop



Part Weight: 0 lbs

Job Created: 2/26/20

Due Date: 4/3/20

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG D5805 REV.A IPP REV:A NEW ISSUE 20.01.15 JV VERF:DD

Ship Via:

## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	4/3/20		0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	4/3/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		EL
120	QC 5	1 pcs	4/3/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 66		



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S268283



Part: D5805-041

Job No: 207469

Serial No/Batch: S268283

Revision: REV.A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/01/20

Plex 3/11/20 3:54 PM Dart.Renwick.Jennifer

				QC 5 - 9	
				QC 5 - 50	12
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Packaging 3-1 - Stock - B4B	1 pcs	4/3/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	12
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	1 pcs	4/3/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-05 APR 02 2020

Part Op 100 - 1- Fabricate as per D5805-041 dwg 2- Weld per dwg A/R 4130706 Batch: 159072 USE DT10689\*\*\*  
 Descriptions: 110 - QC9- Inspect visual per OSI004- Fusion Welds  
 120 - QC5- Inspect part completeness to step on W/O  
 130 - Identify as per dwg & Stock Location: W/1001  
 140 - QC21- Final Inspection - Work Order Release

## Job BOM

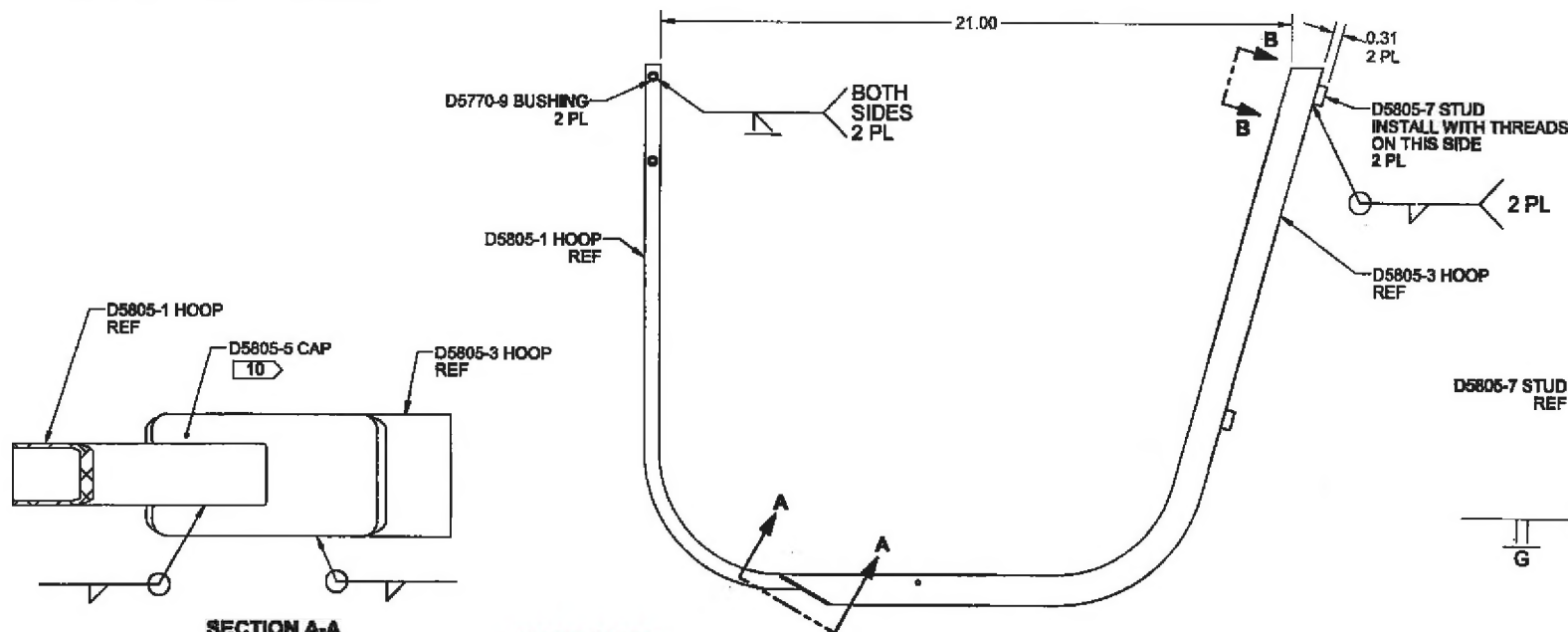
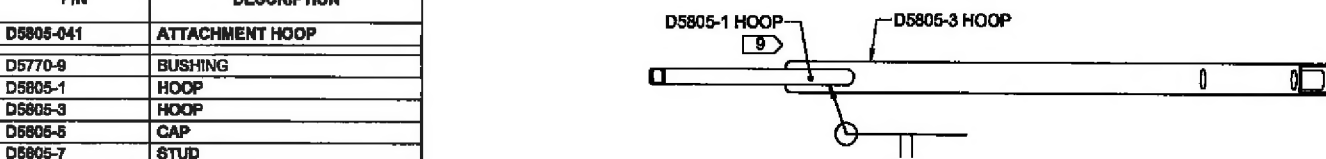
Part / Item	Component Name	Quantity	Operation	Container	
D5770-9	Bushing	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	52624625	259373
D5805-1	Hoop	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5261900	
D5805-3	Hoop	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5264657	5261469
D5805-5	Cap	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5261675	
D5805-7	Stud	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5261615	



Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D5770-9	2	12	0
	D5805-1	1	4	0
	D5805-3	1	4	0
	D5805-5	1	4	0
	D5805-7	2	24	0
Part Specifications				
Specifications could not be found.				

Plex 3/11/20 3:54 PM Dart.Renwick.Jennifer

QTY -041	P/N	DESCRIPTION
X	D5805-041	ATTACHMENT HOOP
2	D5770-9	BUSHING
1	D5805-1	HOOP
1	D5805-3	HOOP
1	D5805-5	CAP
2	D5805-7	STUD



**SECTION A-A**  
SCALE 4X

**D5805-041 ATTACHMENT HOOP**  
(DERIVED FROM AERO DESIGN P/N 76423-01)

**VIEW B-B**  
SCALE 4X, 2 PL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 207469

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 2.42 lbs
  - 8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.
  - 9) GRIND END OF D5805-1 HOOP TO FIT SLOT OF D5805-3 HOOP
  - 10) GRIND SLOT OF D5805-5 CAP TO FIT D5805-1 HOOP

**RELEASED**

2020 FEB 18 *NP*  
ECN 2020-521

REV.	A	NEW ISSUE	DESCRIPTION	ZF	20.01.13
DESIGN	ZF				
DRAWN	ZF				
CHECKED	KPT				
MFG. APPR.	DD				
APPROVED	NO				
DE APPR.	CP				
DATE	20.01.13				

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5805

TITLE

ATTACHMENT HOOP

COPYRIGHT © 2020 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR DISCLOSED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

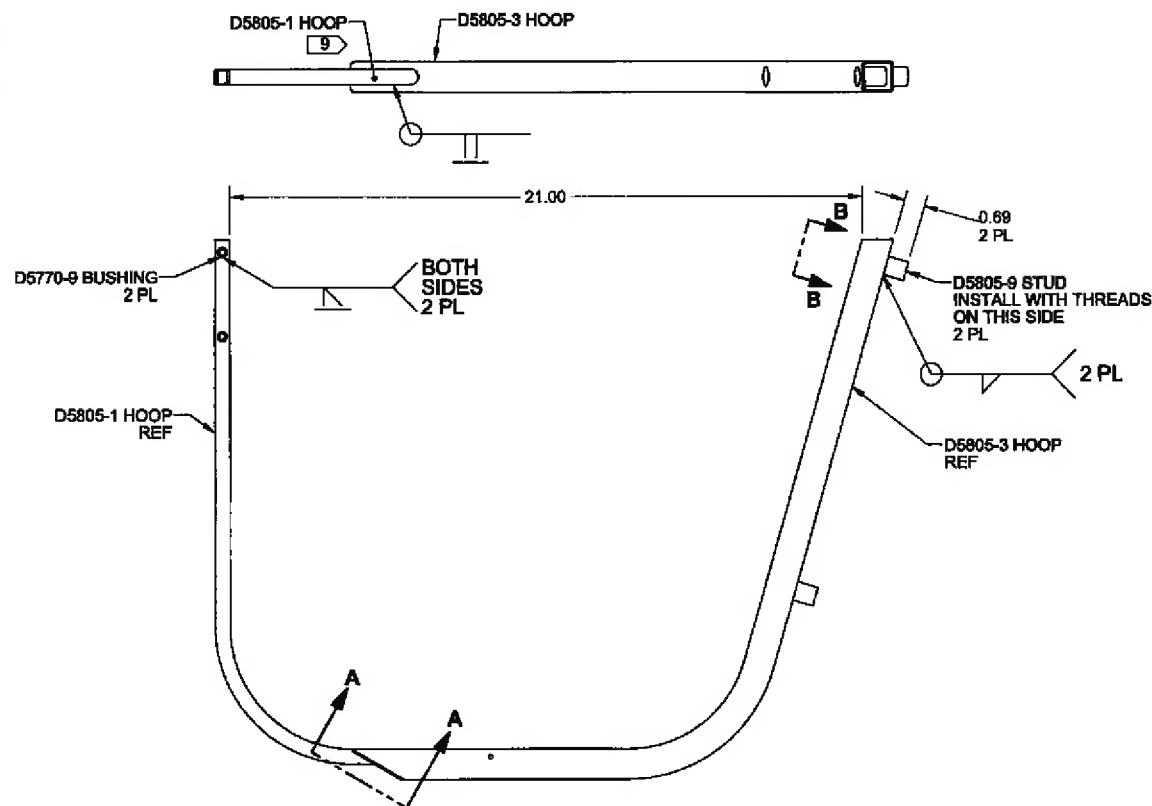
REV. A

SHEET 1 OF 6

SCALE

NTS

QTY -043	P/N	DESCRIPTION
X	D5805-043	ATTACHMENT HOOP
2	D5770-9	BUSHING
1	D5805-1	HOOP
1	D5805-3	HOOP
1	D5805-5	CAP
2	D5805-9	STUD



**D5805-043 ATTACHMENT HOOP**  
(DERIVED FROM AERO DESIGN P/N 78423-07)

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

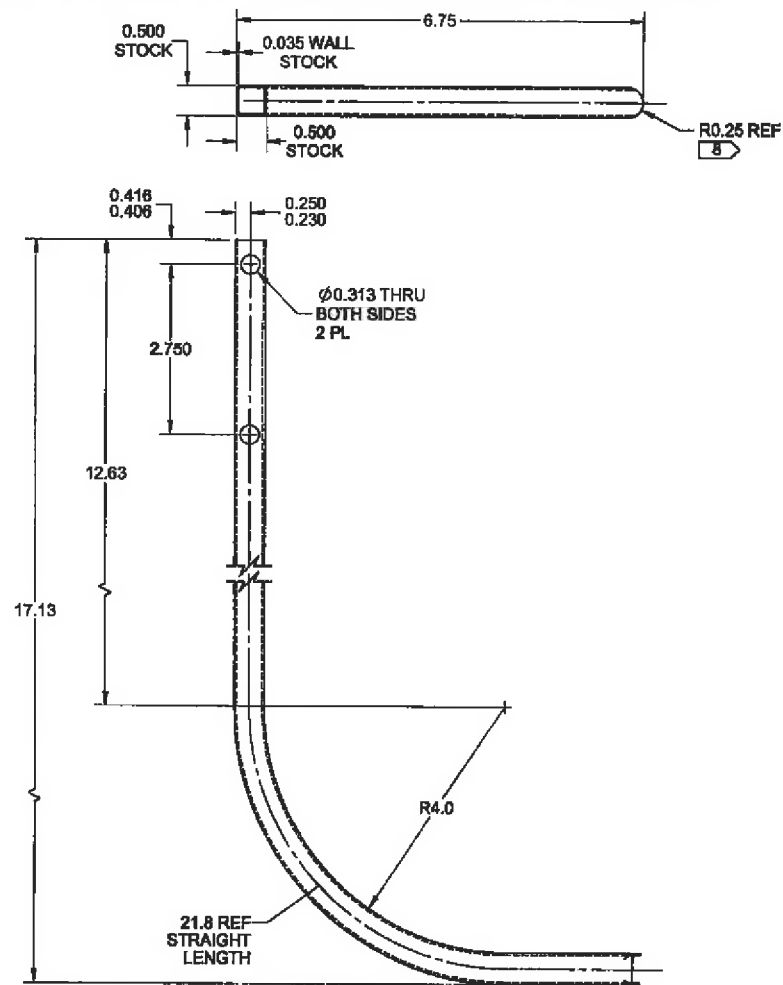
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 2.49 lbs
- 8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.
- 9) GRIND END OF D5805-1 HOOP TO FIT SLOT OF D5805-3 HOOP
- 10) GRIND SLOT OF D5805-5 CAP TO FIT D5805-1 HOOP

**RELEASED**  
2020 FEB 18 *ND*

APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b>	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	<b>D5805</b>	SHEET 2 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<b>ATTACHMENT HOOP</b>	NTS
DATE	20.01.13	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS APPLIED TO THE SUPPLY CHAIN CONTRACT WITH IT NOT TO BE USED FOR ANY PL, SPARE OR COPIES OR COMMERCIALITY IN ANY OTHER FORM OR MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



**D5805-1 HOOP**

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

**NOTES:**

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1/2 X 0.035 WALL  
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374  
REF DART SPEC M4130N-TS0.500W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.37 lbs
- 8) GRIND END TO FIT SLOT OF D5805-3 HOOP AT ASSEMBLY

**RELEASED**  
2020 FEB 18 MD

APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b>	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	<b>D5805</b>	SHEET 3 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<b>ATTACHMENT HOOP</b>	NTS
DATE	20.01.13	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE RELEASED OR DISCLOSED TO THE PUBLIC OR TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

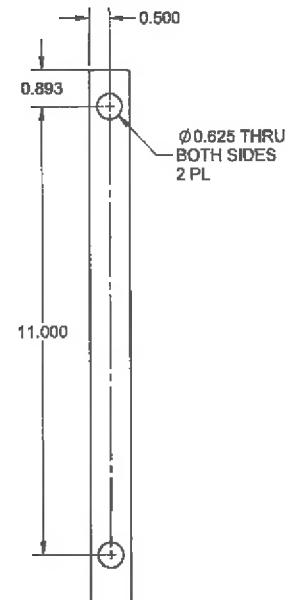
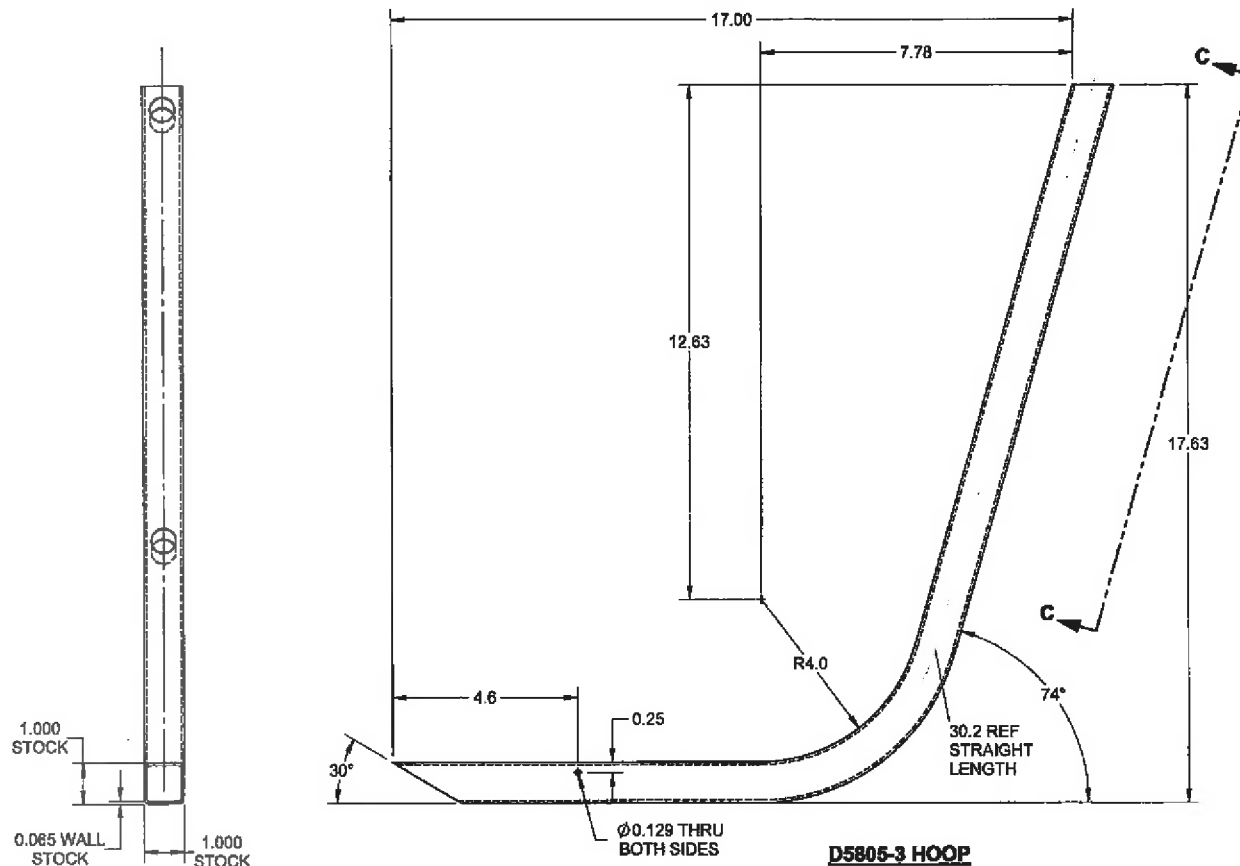
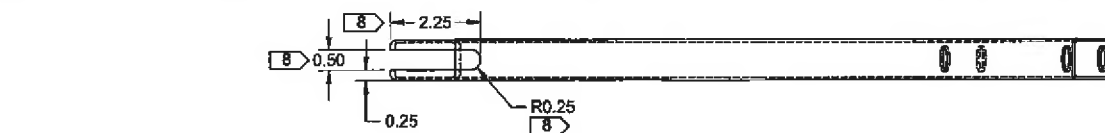
8 7 6 5 4 3 2 1

D

C

B

A



**VIEW C-C**

**D5805-3 HOOP**

**NOTES:**

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1 X 0.065 WALL  
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374  
REF DART SPEC M4130N-TS1.000W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.84 lbs
- 8) GRIND SLOT TO FIT D5805-1 HOOP AT ASSEMBLY.

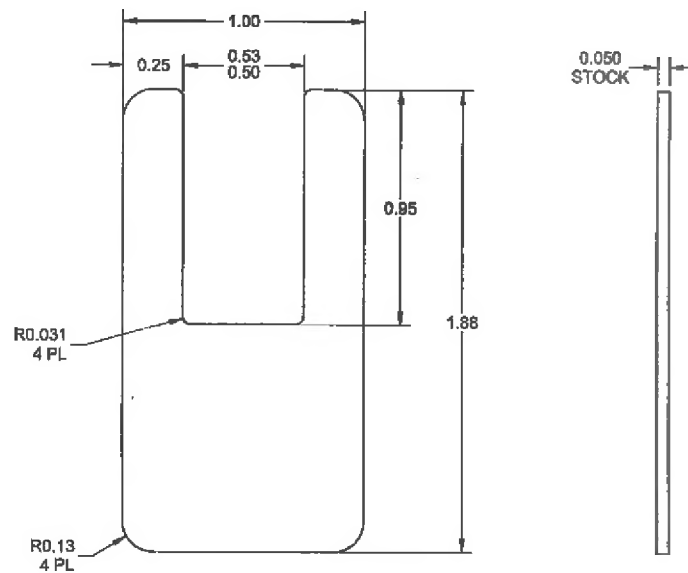
**RELEASED**  
2020 FEB 18 NO

APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D5805</b> TITLE <b>ATTACHMENT HOOP</b> COPYRIGHT © 2020 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A
DRAWN	ZF		SHEET 4 OF 8
CHECKED	KPT		SCALE
MFG. APPR.	DD		NTS
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.13		

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

8 7 6 5 4 3 2 1



**D5805-5 CAP**  
(DERIVED FROM AERO DESIGN P/N 76423-04)

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

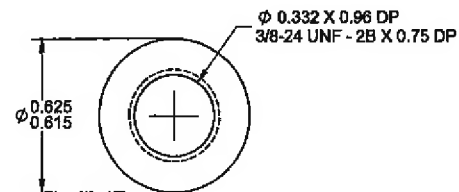
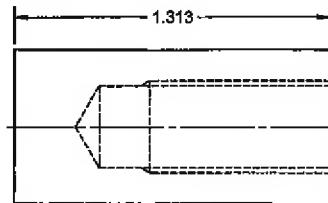
- NOTES:
- 1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #18 GA (0.060 THICK)  
PER ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W  
REF DART SPEC M1010-S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.02 lbs

**RELEASED**  
2020 FEB 18 *ND*

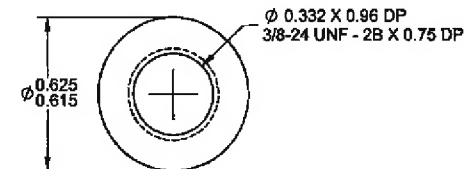
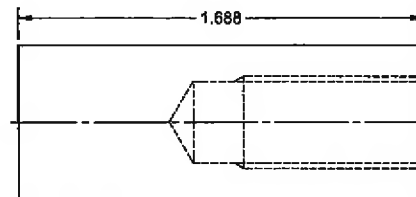
APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b>	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	<b>D5805</b>	SHEET 5 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	CP <i>40</i>	<b>ATTACHMENT HOOP</b>	NTS
DATE	20.01.13	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND NOT TO BE RELEASED OR DISCLOSED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.</small>	





**D5805-7 STUD**  
(DERIVED FROM AERO DESIGN P/N 76423-06)



**D5805-9 STUD**  
(DERIVED FROM AERO DESIGN P/N 76423-06)

UNDER REVIEW  
URF 2020-522 20.02.14 (NO)

**NOTES:**

- 1) MATERIAL: AISI 1018/1025 STEEL ROUND BAR  
PER MIL-S-7097 OR ASTM A108  
REF DART SPEC M1018-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.09 lbs  
-9: 0.12 lbs

**RELEASED**  
2020 FEB 18 NO

APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D5805</b> TITLE <b>ATTACHMENT HOOP</b> COPYRIGHT © 2020 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A
DRAWN	ZF		SHEET 8 OF 8
CHECKED	KPT		SCALE
MFG. APPR.	DD		NTS
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.13		

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
<b>Root Cause</b>  <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<b>FAULT CATEGORY</b>  <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>			
Other/Details:					